

ABSTRACT OF THE DISCLOSURE

A ratio of length (L) / diameter (D) of a screw is set to 18 through 24, a length (Lf) of a supplying portion of the screw is set to 10 through 14 times the diameter (D), a groove depth (hf) of the supplying portion of the screw (14) is set to be not less than 13mm, a groove depth (hm) of a measuring portion of the screw (14) is set to be not less than 8mm, and a width of a molten resin path formed by a weir plate (22) and a check ring (22) in a direction orthogonal to a flow direction of the molten resin is set to be 3 through 6 % of the screw diameter (D).